

Need finished for Monday June 4

Work Order ID 85034

May-31-12 3:12:19 PM

\*85034\*

Page 1

Item ID: D2195-2

Accept

\*N9000040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Bracket

Stop

\*NS2\*

Start Date: 31/05/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 14/06/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/05/31

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2195

Rev D

100

0.00

\*100\*

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2195-1Dwg Rev: 0 Prog Rev: 0 2-  
Deburr if necessary

32

0

JM

12-6-07

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

Quality Control

32

0

JM

12-6-07

120

QC8- Inspect parts - second check

0.00

\*120\*

QC

Memo

0.00

Quality Control

Sc 12/06/07

(A)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 85034

May-31-12 3:12:19 PM

**\*85034\***

Page 2

Item ID: D2195-2

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Bracket

Stop **\*NS2\***

Start Date: 31/05/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 14/06/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> Brake NC Brake NC	NC BRAKE  Memo Bend as per dwg D2195	0.00  0.00				2			8/12/06/01
140 <b>*140*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00				(12)			
150 <b>*150*</b> Packaging Packaging	Identify as per dwg & Stock Location: <b>G-A</b>  Memo	0.00  0.00				2x			8/12/06/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 85034**

May-31-12 3:12:19 PM

**\*85034\***

Page 3

Item ID: D2195-2

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Bracket

Start Date: 31/05/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 14/06/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

**\*160\***

QC

Memo

0.00

Quality Control

12/6/12

ME  
12-06-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

May-31-12 3:12:24 PM

Page 1

Work Order ID: 85034

\*85034\*

Parent Item: D2195-2

\*D2195-2\*

Parent Item Name: Bracket

Start Date: 31/05/2012

Required Date: 14/06/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-07-24 new issue ec verified by:dd  
IPP Rev:B 09-01-28 rev.d as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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No

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0.366 SF

B<sup>#</sup> 121626

JM  
12-8-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 85034
<b>Description:</b> Bracket		<b>Part Number:</b> D2195-2
<b>Inspection Dwg:</b> D2195	<b>Rev:</b> D	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	0.128"	✓		✓	mm01
Ø0.203	+0.005/-0.001	0.203"	✓		✓	
Ø0.257	+0.006/-0.001	0.261"	✓		✓	
0.375	+/-0.010	0.365"	✓		✓	
1.200	+/-0.010	1.191"	✓		✓	
2.390	+/-0.010	2.380"	✓		✓	
5.890	+/-0.010	5.888"	✓		✓	
7.090	+/-0.010	7.082"	✓		✓	
7.590	+/-0.010	7.587"	✓		✓	
4.140	+/-0.010	4.135"	✓		✓	
0.336	+/-0.010	0.332"	✓		✓	
1.273	+/-0.010	1.274"	✓		✓	
2.211	+/-0.010	2.207"	✓		✓	
3.149	+/-0.010	3.147"	✓		✓	
3.524	+/-0.010	3.532"	✓		✓	
0.063	+/-0.010	0.060"	✓		✓	

<b>Measured by:</b> Jm	<b>Audited by:</b> S	<b>Preliminary Approval:</b>	N/A
<b>Date:</b> 12-6-01	<b>Date:</b> 12/06/01	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	08.03.27	New Issue	KJ/DD	
B	10.08.03	Dimensions updated per Dwg Rev D	KJ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM No.	QTY	PART NUMBER	DESCRIPTION
1	X	D2195	BRACKET ASSEMBLY
7	1	D2195-1	BRACKET
8	1	D2195-2	BRACKET
9	1	D2195-3	SPACER
15	6	MS20470AD4-14	RIVET

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 85034 MLJ  
12/05/31

RELEASED  
09/01/13/11/8

**NOTES:**

- 1) MATERIAL:
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2195" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.26 lbs

D	RE-DESIGN. REF NCR 08-110.	AJS	08.11.25
C	REDRAW: D2195-3 NOW 0.5" THICK	CP	03.05.28
B	RE-DESIGN	JB	93.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<u>3</u>	DRAWING NO.	REV. D
MFG. APPR.	<u>3</u>	D2195	SHEET 1 OF 3
APPROVED	<u>4</u>	TITLE	SCALE
DE APPR.	<u>4</u>	BRACKET	NTS
DATE	08.11.25	<small>COPYRIGHT © 1993 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

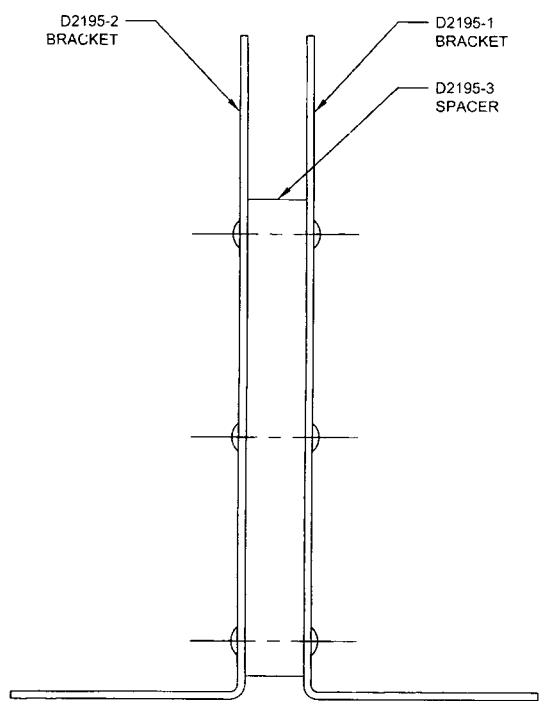
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

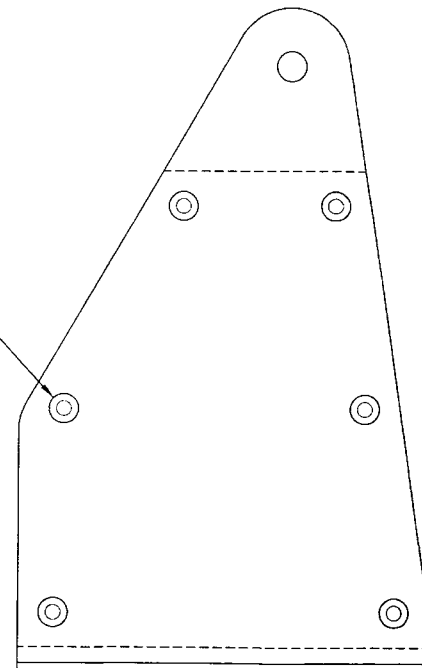
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

25034



MS20470AD4-14  
RIVET  
6 PL



D2195 BRACKET ASSEMBLY

**RELEASED**  
27/01/15

DESIGN	JB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	2	DRAWING NO.	REV. D
MFG. APPR.	E	D2195	SHEET 2 OF 3
APPROVED	AN	TITLE	SCALE
DE APPR.	AN	BRACKET	NTS
DATE	08.11.25	<small>COPYRIGHT © 1993 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

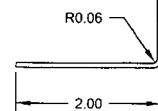
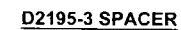
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Detail of the corner of the plate showing a fillet weld with a radius  $R0.06$  and a length of  $2.00$ .

**D2195-1 BRACKET**  
MAKE FROM D2195-1F

2) FINISH: -3 ONLY: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: N/A  
7) WEIGHT: SEE ASSEMBLED WEIGHT

RELEASED  
09/01/15 JH

DESIGN	JP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA  DRAWING NO. D2195 TITLE BRACKET  COPYRIGHT © 1993 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS SUPPLIED ON THE EXPRESS COVENANT THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR REPRODUCED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD	REV 0
DRAWN	AJS		SHEET 3 OF 3
CHECKED			
MFG. APPR.			
APPROVED			SCALE
DE APPR.			NTS
DATE	08.11.25		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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